Wednesday, 11/21/2007 12:50:25 PM

**Process Sheet** 

Customer

: CU-DAR001 Dart Helicopters Services

Type

Job Number : 35930B

**Estimate Number** 

: 10729

P.O. Number

Prsht Rev.

First Issue

This Issue

AIN:

: 11/21/2007 : NC : MA

: 34291B

S.O. No. : NA

: SMALL /MED FAB

**Part Number Drawing Number** 

**Drawing Name** 

: D23245

: STRAP

D2324 REV C : N/A

Project Number **Drawing Revision** 

Material **Due Date**  : 12/20/2007

Qty:

40 Um:

Each

**Previous Run** Written By

Checked & Approved By Comment

: Est.

É 03:02.28

Reformat; Incorporated D2324-3 & D2324-5 K

J/RF

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S16GA

304/316 .063 Sheet

.9384 (058)4 × 31=.5764

Comment: Qtv.:

0.0184 sf(s)/Unit Total:

R07-12

0.7360 sf(s)

83E. OF X OSIZOI

2.0

FLOW WATER JET

304/316 .063 Sheet



Comment: FLOW WATER JET

1-Cut as per Dwg D2324

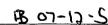
Dwg Rev: \_\_\_\_

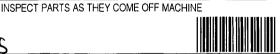
2-61-50 Bi

Prog Rev:\_\_\_

2-Deburr if necessary

3.0





Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2324-5T1

4.0

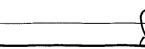
QC8

SECOND CHECK

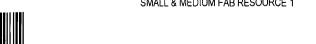


Comment: SECOND CHECK

SMALL FAB 1

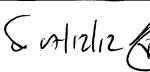


SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary





Salizliz Kos

## Dart Aerospace Ltd

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W/O:			WC	RK ORDER CHANGE	S			;	
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A: 🔼	∑ Date: ∠	11/2/13
					QA: N	/C Close	d:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	3)			
5.475	0777	Description of NC		n B	Verific	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng Q	QC Inspector
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NOTE: Date & initial all entries

Wednesday, 11/21/2007 12:50:25 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: STRAP Customer: CU-DAR001 Dart Helicopters Services Job Number: 35930B Part Number: D23245 Job Number: Seq. #: Description: Machine Or Operation: PACKAGING RESOURCE #1 PACKAGING 1 6.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:\_ 7.0 Comment: FINAL INSPECTION/W/O RELEASE min 2007/12/13 Job Completion

Dart Ae	rospace Li	td							, l	
W/O:			WC	RK ORDER CH	ANGES			_		
DATE	STEP	PR	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cated	iory:	NC	R· Yes	No DO	Δ.	Date	
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NCR:		,	WORK ORD	ER NON-CONFO	RMANC	E (NC	R)		,	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descrip	Section B otion	Sign Date	& Sect	<b>cation</b> ion C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

6	
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DART AEROSPACE LTD	Work Order:	35930B	
Description: Strut	Part Number:	D2324-5	
Inspection Dwg: D2324 Rev: C		Page 1 of 1	

	FIRST ARTICLE INSPECTION CHECKLIST									
	X	First Article Pro			rototype					
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments			
R0.38	+/-0.030	.38	X							
Ø0.257	+0.006/-0.001	,358	x							
Ø0.191	+0.005/-0.001	,192	¥							
0.750	+/-0.010	o2Fi	þ							
0.375	+/-0.010	375	8							
1.875	+/-0.010	1.875	×							
3.000	+/-0.010	3,000	¥							
3.375	+/-0.010	3,373	*							
	100									
		<del>-</del>								
		·								
Measured by: γ	B	Audited by:	٦,		Prototype App	roval:	N/A			
Date: (	27-12-5	Date:	2/11/1			Date:	N/A			
Rev Date	Change					ised þ <u>y</u>	Approved			
A 06.06.05	New Issue				KJ/J	ILM A	-   5/11/			



	DESIGN DRAWN BY  B WILLIAMS PH		DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA					
CHECK		APPROVED.	DRAWING NO.	REV. C				
	#	#	D2324 SHEET	1 OF 1				
DATE			TITLE	SCALE				
04.1	12.14		STRUT					
. A		94.11.08	NEW ISSUE					
В		96.05.07	UPDATE MATERIALS					
С		04.12.14	UPDATE NOTES					

02324-5

AN3-12A BOLT (1) AN960JD10 WASHER (2) MS21042L3 NUT (1)

(TWO PLACES)

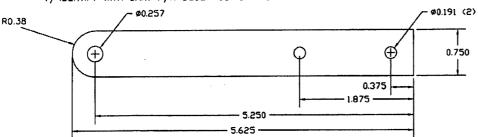
RELEASED 04.12.16

> 6.000(REF) 0

D2324-3

D2324 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75

(REF DART SPEC. M6061T6B0.750X00.750)

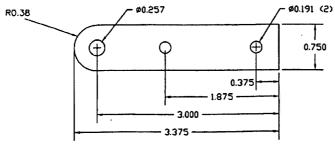
2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 2) FINISH:

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURNIO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT

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